

Work Order ID 69285

Friday, May 06, 2011 11:48:45 AM



Page 1

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 16.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date: *11-05-11*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary

304 . 040

1811-5-10



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1811-5-10

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/11



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Debur if necessary ☐ 2-Form on Brake as per Dwg D3793 using Jigs ☐ 3-Form
Joggle on brake using Jig as per Dwg D3793

SP 4/6/5/11



140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S 4/6/5/11



150

0.00



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00 ☐ OVEN TEMPERATURE:
FINISH TIME: 10:30

3250F

10:30

17x 10 M-1 4/6/5/12

M 11/5/128

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Work Order ID 69285

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Page 3

Item ID: D3793-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 5/6/2011 Start Qty: 16.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

17 BR 11-5-12

170

Identify as per dwg & Stock Location: EP-18 0.00

Packaging

Memo

0.00

Packaging

17 BR 11-5-12

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/13 [Signature]ME
11-05-12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, May 06, 2011 11:48:52 AM

Page 1

Work Order ID: 69285



Parent Item: D3793-1

Parent Item Name: Wearshoe

Start Date: 5/6/2011

Required Date: 5/9/2011

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

100

sf

115.7000

0.5902

9.940211



1311-5-10

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

115.7

116623

0.2

117550

115.5

117550



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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69285
Description: Wearshoe		Part Number:	D3793-1
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.193	✓		V KB02	
0.300 x 0.300	+/-0.010	0.303 x 0.304	✓		V	
1.885	+/-0.010	1.889	✓		V	
2.000	+/-0.010	2.001	✓		V	
5.00	+/-0.030	5.002	✓		T KB01	
8.00	+/-0.030	8.000	✓		T	
14.00	+/-0.030	14.000	✓		T	
20.00	+/-0.030	20.000	✓		T	
14.066	+/-0.010	14.066	✓		V	
18.983	+/-0.010	18.983	✓		V	
23.900	+/-0.010	23.900	✓		V	
27.400	+/-0.010	27.400	✓		V	
29.400	+/-0.010	29.400	✓		V	
32.900	+/-0.010	32.900	✓		V	
0.040	+/-0.010	0.037	✓		V	

Measured by:	IB	Audited by:	J	Prototype Approval:	N/A
Date:	11-5-10	Date:	11/05/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	

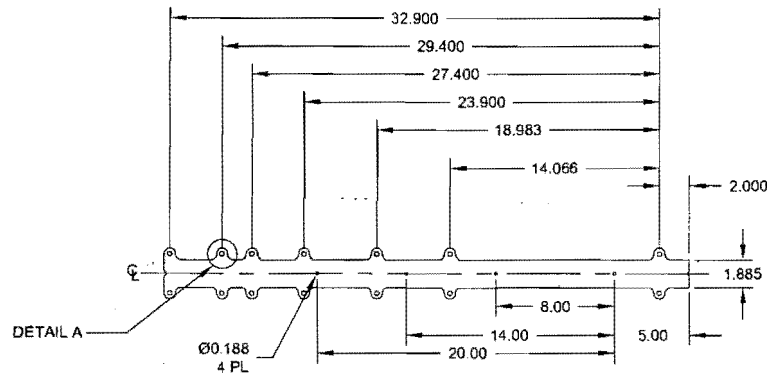
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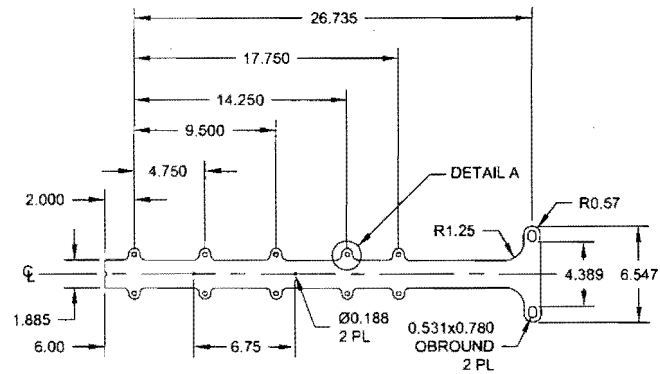
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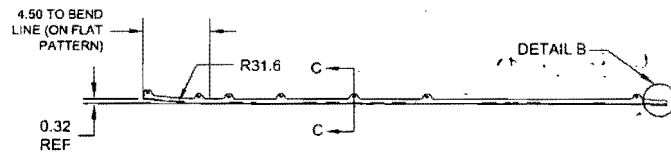
NOTE: Date & initial all entries



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08-05-14

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09285

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN	PH		BY	DATE
DRAWN	PH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

DART AEROSPACE USA, INC	REV. A
PORT HADLOCK, WA	SHEET 1 OF 2
DRAWING NO. D3793	SCALE
TITLE WEARSHOE	NTS

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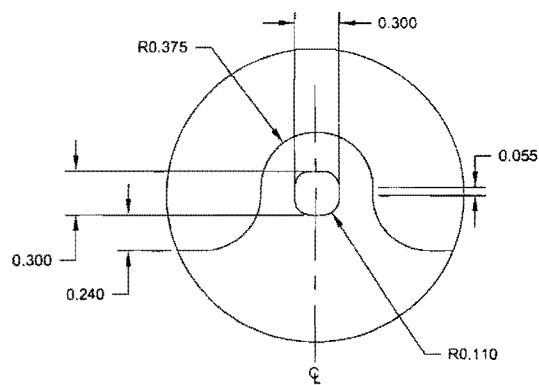
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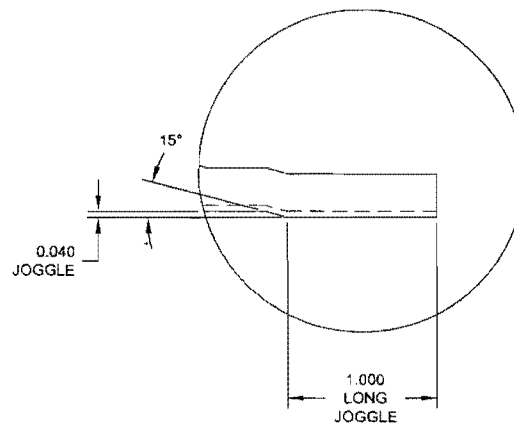
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D



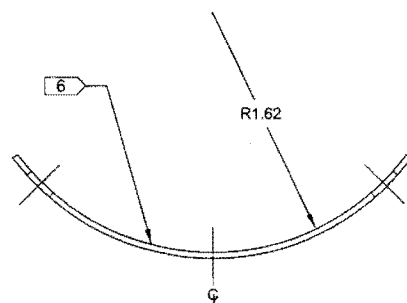
DETAIL A
SCALE 10X



DETAIL B
SCALE 10X

C

B



SECTION C-C
SCALE 10X

RELEASED
08-05-25/14

wb 69285

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO. D3793	REV. A
MFG. APPR.	PH	SHEET 2 OF 2	
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

A

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